

5/24

DART AEROSPACE LTD		Work Order:	23556
Description: 206 L/L-1/L-3/L-4 HighGear Web		Part Number:	D2654-7
04.08.17 KJ 04.08.17 QP			
Drawing: D2654 Rev. D E1		Qty:	3

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	HJ	05.06.14	3
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-7 Web 321966			
3	METAL	Cut D2600-7 to length as per Dwg D2654 (116.00") DM 99.08.19 04.07.07		05/06/14	3
4	METAL	Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654		05/06/14	3
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654		05/06/14	3
6	METAL	Deburr holes and ends		05/06/14	3
7	METAL	Acid Etch and Alodine as per QSI 005 4.1		05/06/14	3
8	QC	Inspect Level 5	ML	05.06.20	3
9	METAL	Identify and stock		05-06-20	3
10	EXPEDITING	Close Work Order Cost/part: 40.15/36.16	BIE	05-06-20	3
			HJ	05.06.28	05/06/28

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	(S)

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9- 89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

RELEASED
DM 99.02.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector






NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

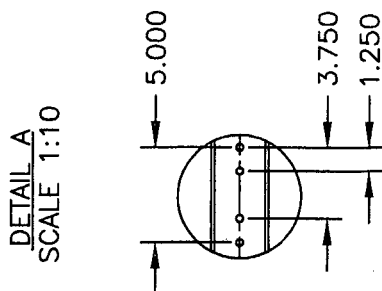
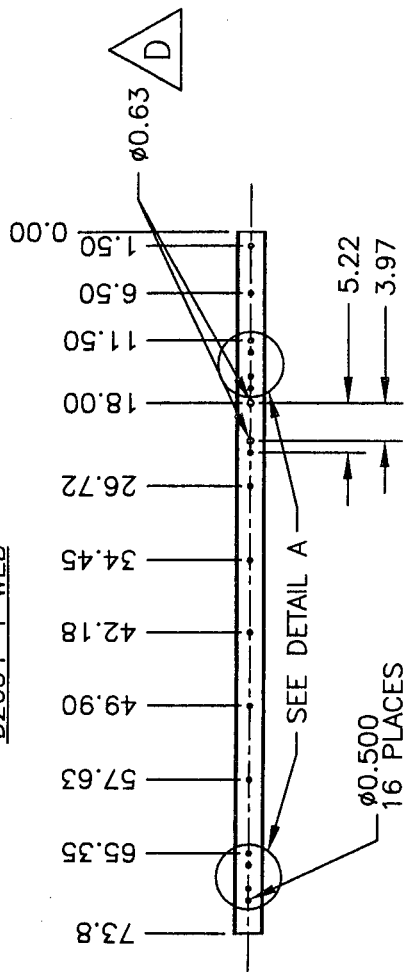
QA: N/C Closed: _____ Date: _____



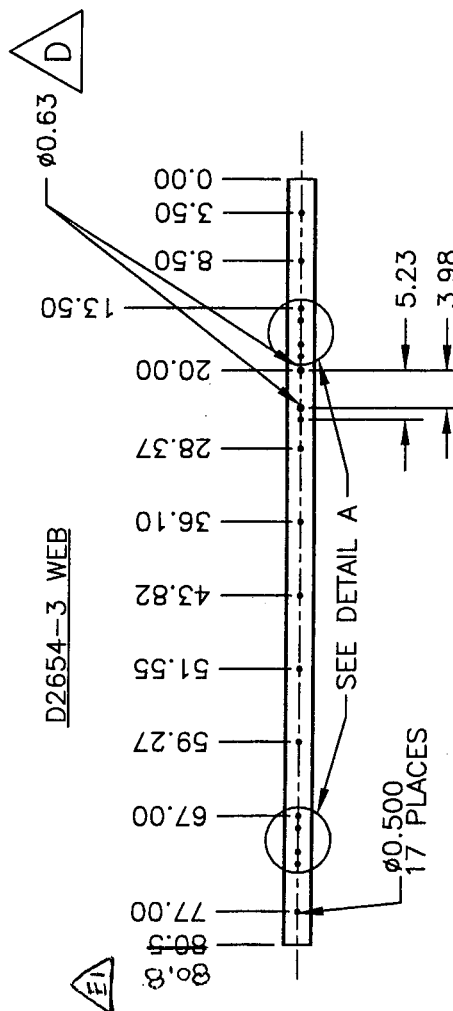
DESIGN 	DRAWN BY 	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1 	04.08.04	PER TOOLING; 80.8 WAS 80.5	

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB



SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23556

MADE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 10, 2005
01:45 pm

Work Order No	:	0023556	Department Code:	
Project Name	:	D2654-7	Burden Flags	: NNNNNNNN
Project For	:	WK526	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2654-7	Invoice Number	:
Description	:	206 I Beam (Web)	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	3	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	06-10-05		
Est Finish Date	:	06-30-05	Est Mark Up	: 0.000%
Act Finish Date	:		Actual Mark Up	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00